Work Order I August-23-13 9:27:2			*105884*								
Revision ID:	32-3 et Hinge /13		Accept	*N900		100)* s	Setup Sta	1.77	S1* S2*	
Required Date: 9/06 Reference:	/13 Req'd Qty: 20.00			Customer							
	ocess Plan: MUS	_ /	> Tooling: SPC (Y/N):		Date:	- · ———	R	tun Sta Sto	υ [V]	R1* R2*	
Sequence ID/ Work Center ID	Operation - Description	`	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	,
Draw Nbr	Revision Nbr					,					-
D2232	Rev C					\					
*100 *100* Waterjet FLOW CNC Waterjet 304 · 125	FLOW WATER JET Memo 1-Cut as po Deburr if n	or Dwg D2232 Dwg Rov: eccessary	0.00 0.00 Prog Rev:	2-		-	24	_0		JM13-0	&-58
¹¹⁰ *11∩*	QC2- Inspect parts off	machine FAI/FAIB	0.00	· .			24	- 0		JMBA	25-8C
QC Quality Control	Memo		0.00							,	
120	QC8- Inspect parts - sec	cond check	0.00 27 7 3:89				-1 1				
120 QC	Мето		0.00 13-8. 3	99			<u> </u>				

Quality Control

											DQA:	Date	e:
NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFORM	/ANCE / UP	DATE	QA Closed:	Date	2:
Work Orde				- :		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	T	Initial	Ac ⁻	tion	Sign &		
Cause	ŀ	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								T CATE	GORY				
Landi	ng G	ear				General		- CATE			· · · · · · · · · · · · · · · · · · ·		
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Torque Waves in Extrusion				n	Drawing	L	Out of C	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde August-23-13 9		5884	*105884*									Page 2
Item ID: Revision ID: Item Name:	D2232-3 Basket Hinge			Accept	*N900	04 0	100)*	Setup	Start Stop	*NS	- •
Start Date: Required Date: Reference:	8/23/13 9/06/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item [Customer:	D:						
Approvals:		n:		Tooling: SPC (Y/N):		ite:			Run	Start Stop	*NF	?1* ?2*
Sequence ID/ Work Center II 130 *120* Small Fab Small Fab	D	Operation Description Small Fab Memo Deburt	nck Location: <u>UDF</u> CO	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Code		Qt)	, r 13-c	Number 5	Insp. Stamp
140 Packaging Packaging		Memo *****STOCI	K IN BASKET CELL****	0.00	P13-8-25	` `	~	SS	_13_	·08	.29	 -
*150 *150* QC		QC21- Final Inspection -	Work Order Release	0.00						13	19/3	8
Quality Control										, 1	829	

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE		•			
						_						QA Closed:	Da	ite:	
Work Orde	or.					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Work Orde	ÇΙ.,					Rework	1		Skid-tube	Crosstube	٦	Water Jet			Engineering
Part I	No.					Scrap Machining Sma			Small Fab	Prod. Eng. Coor.			Quality		
ı		···				Use-as-is				Finishing	Rec/Store/Packaging			_	Other
NCR I	No.					Work Order Update	<u>ן</u>		Large Fab	Composite	_		Supplier	_	
Root			1		Descr	iption of work order update	Ţ	Initial	Ac	tion	٦	Sign &			
Cause		Date	Step	Qty	L	or Non-conformance	Ch	nief Eng	Desc	ription	\bot	Date	Verificatio	n	QC Inspector
Doc/Data		,	Į .												
Equip/Tooling	Ш										١		,		
Operator	Ш										-			i	
Material	Ш		1												
Setup	Ш						1								
Other	Ш		}												
Process	Ш		İ	i											
Supplier	Ш		1								Ì			1	
Training	Ш														
Unapproved			<u> </u>	<u> </u>					<u> </u>	·	$oldsymbol{\bot}$				
						F	AUL	T CATE	GORY						
Landi	ing (ear				General		_			_				-
		Bending				Bend		Grain		L	_∫	Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire			Over/Under	tolerance		Temperature/Cure
					Broken/Damaged		Inspection Incomplete				Part Incorrec	:t		Weld	

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short Drill Holes

Drawing Finish

Folio

Picklist Print

August-23-13 9:27:32 AM

Work Order ID: 105884

105884

D2232-3

Parent Item Name: Basket Hinge

Start Date: 8/23/13

Required Date: 9/06/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

Parent Item:

B01.06.07Now laser cutEC

IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	285.6933	0.0694	1-46T053		· = · · · ·	
M304S110	GA								**	20		」か	13.08-28

304/316 0.125 Sheet

Location	Loc Qty	Loc Code	
MAT020	285.6932632		
122521	19.1432632		
124445	92.54		124445
M126075	174.01		

Page 1

										DQA:	Dat	:e:	
NCR: Y	'es / No				WORK ORDER NON-C	CON	FORM	MANCE / UPDATE	c	QA Closed:	Dat	te:	
Work Orde					DISPOSITION			AGAINST	DEP	ARTMENT/	PROCESS		
Part N	lo				Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Other
Root		Ì		Descri	ption of work order update	In	itial	Action		Sign &	<u></u>		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Description		Date	Verification	٦	QC Inspector
Doc/Data													
Equip/Tooling												- {	
Operator	7											-	
Material	_											1	
Setup		1											
Other													
Process				ł					- 1				
Supplier									- 1				
Training									1				
Unapproved		1				1						\perp	
					F	AULT	CATE	GORY		~			
Landi	ng Gear				General						_		
	Bending				Bend		Grain			Ovalized		Pre	essure/Forced
	Centre I	Not Conce	ntric to	o/s	BOM/Route		lardwa	re		Over/Under	tolerance	Te	mperature/Cure
	Cracks				Broken/Damaged		nspecti	on Incomplete	P	art Incorrec	it []we	eld
	Crushed	I/Crimped			Burrs		nstruct	ions Incomplete/Unclear	P	art Lost/Mis	ssing	Wr	rong Stock Pulled
	Cuffs			Г	Contamination		Mainte	enance	P	art Moved	_		
	Heat Treat				Countersink		∕islabe	eled	Р	ositioned W	/rong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

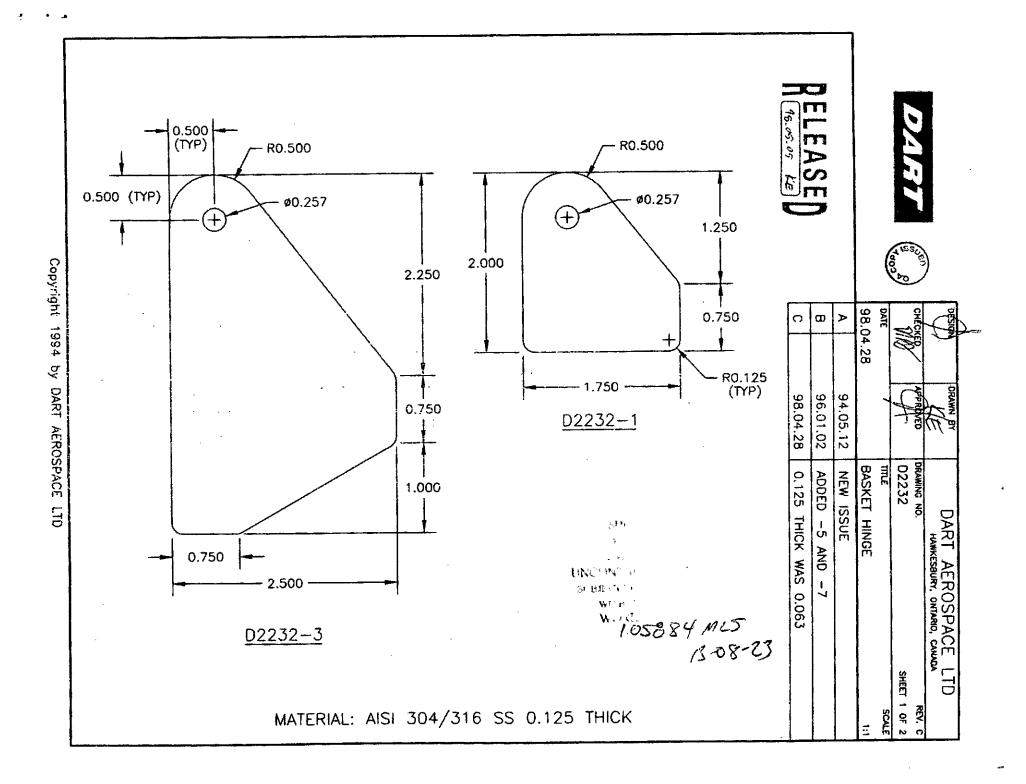
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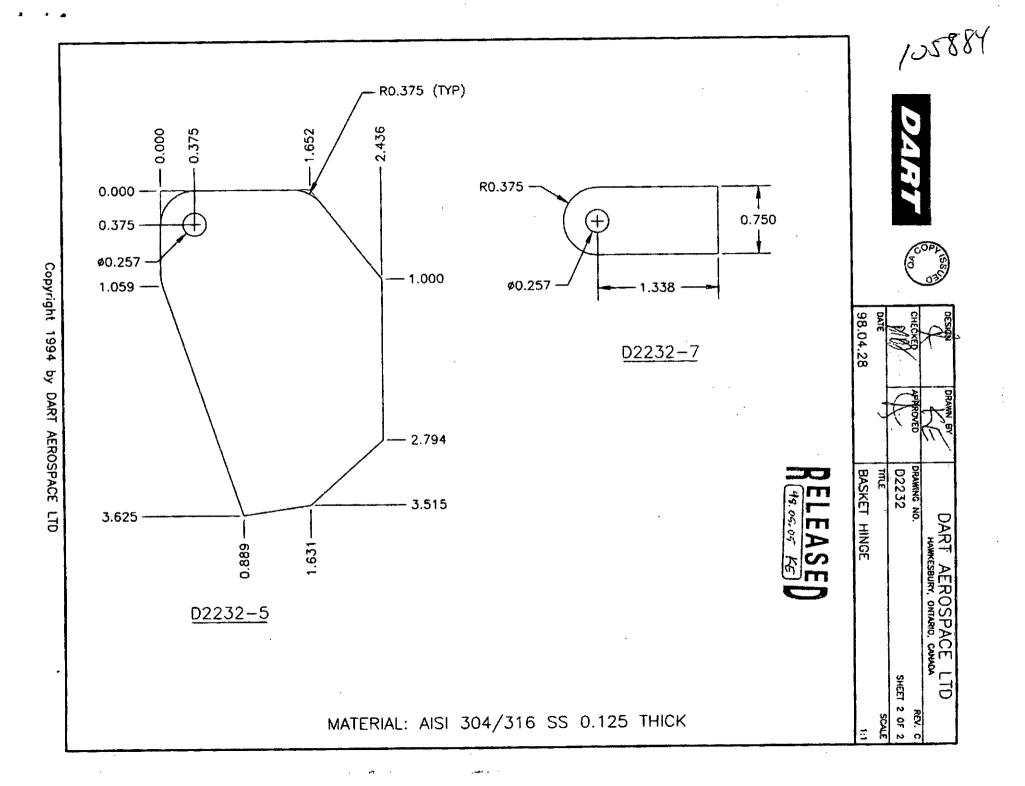
DART AEROSPACE LTD	Work Order:	105-884
Description: Basket Hinge	Part Number:	D2232-3
Inspection Dwg: D2232 Rev: C		Page 1 of 1

Inspection Dwg	j: D2232 Rev :	: C		L		P	age 1 of 1					
FIRST ARTICLE INSPECTION CHECKLIST X First Article Prototype												
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cc	omments					
0.500	+/-0.010	0.500		 -	ν	Jen	01					
0.750	+/-0.010	0.751"	_		~		<u>- I</u>					
2.500	+/-0.010	2.504	-	-	٧	1						
1.000	+/-0.010	1.005			ν	 						
0.750	+/-0.010	0.756	-		V							
2.250	+/-0.010	2.253	_		V							
0.500	+/-0.010	0.504"	_		V		· ·· · · · · · · · · · · · · · · · · ·					
Ø0.257	+0.006/-0.001	0259"	_		V							
							-					
					-							
							···					
			DAS				<u> </u>					
			27				г					
Measured by:	Jm	Audited by:			Prototype /	N/A						
Date:	13-08-28	Date:	13.8.	29		Date:	N/A					
Rev Date	Change				F	Revised by	Approved					

ì	Rev	Date	Change	Revised by Approved
	Α	06.11.08	New Issue	KJ/JLM of E
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